

Date: Friday, 30/05/2008 10:12:50 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PLUG
<b>Job Number</b> : 39601	
<b>Estimate Number</b> : 12337	
<b>P.O. Number</b> :	<b>Part Number</b> : D3492043
<b>This Issue</b> : 30/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3492 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 38563	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/06/2008 <b>Qty:</b> 80 Um: Each
<b>Checked &amp; Approved By</b> : <u>JUL 08-530</u>	
<b>Comment</b> :	
: Est Rev: A 06.03.21 New Issue JLM	
: Est Rev: B 06-08-28 As per Rev B JLM	
: Est Rev: C 07-12-06 Rev C dwg DD verified by: EC	
: Est Rev: D 08-05-07 add note to count qty DD verified by: JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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**Comment:** Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s)  
 6061-T6 Round Bar .750"  
 (M6061T6R750)  
 Batch: M63857

J.F. 08/06/02 (92)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492  
 Dwg Rev: C  
 Folio Rev: AA

J.F. 08/06/02 (92)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/06/02 (92)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

J.F. 08/06/02 (92)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 30/05/2008 10:12:50 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39601

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



PTU

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

\*\*\*\*\*count the qty.\*\*\*\*\*

08/06/04 @ 9 AM

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

27/02 08/06/05

7.0

POWDER COATING

POWDER COATING



M107925

91X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30 PM  
320 °F  
4:00 PM

M-f 08/06/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-09 91X

9.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-013 O-RING

(or MS28775-013)

M106513

M-f

91X

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube  
A/R 55-O'Ring Lube Batch:

M101223

M-f 08/06/12

91X

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3492-043 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: P Date: 08/06/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>39601</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-06-04	5.0	Employee lost 1 part while deburring. Part flew out of his fingers & was lost on the floor.	<i>[Signature]</i> 08/06/12	Qty 91 remaining on W/O. counted by: <u>(CIX)</u> <i>M-L</i> 08/06/12	<i>[Signature]</i> 08-06-04	<i>[Signature]</i> 08/06/12	<i>[Signature]</i> 08/06/12	<i>[Signature]</i> 08/06/12

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:50 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39601

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/12 (X91)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FP2

M-1 08/06/12

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/13

Job Completion



MF 08-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

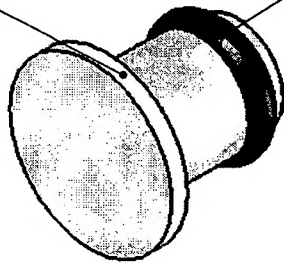
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



**D3492-XXX PLUG PARTS LIST**

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

NOTES:  
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37601

UNDER REVIEW

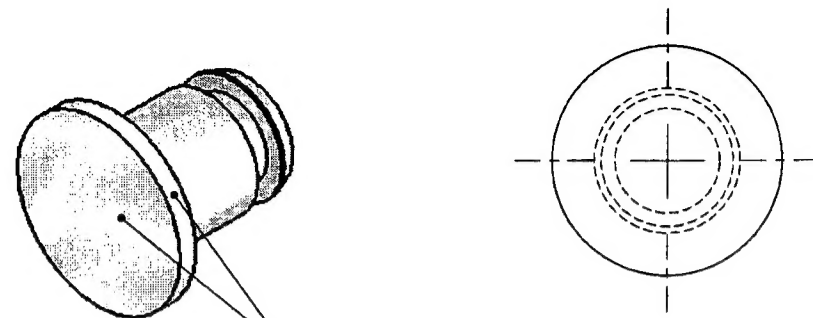
01.04.11  
08.05.30  
DIM 06 ON D3492-13  
REST OK (MAKE SMALLER)

RELEASED  
07.10.16

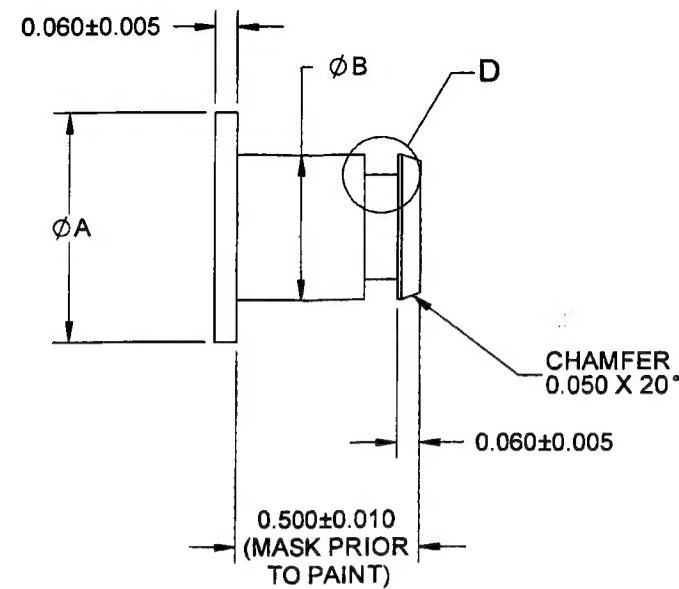
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



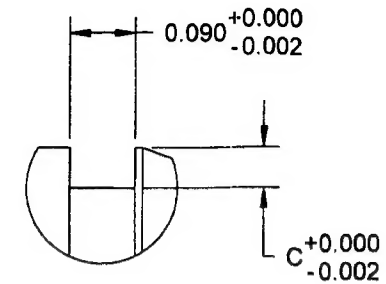




POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39601

**UNDER REVIEW**  
08.05.30  
DIM AB ON D3492-13  
REST OK (HKEE SMALLER)

**RELEASED**  
07.11.16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
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